

Date: Thursday, 3/13/2008 10:19:43 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STEP SPACER
Job Number	: 37925D		
Estimate Number	: 13128		
P.O. Number	:	Part Number	: D37201
This Issue	: 3/13/2008 S.O. No. :	Drawing Number	: D3720 REVA
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: A
Previous Run	: 37452D	Material	:
Written By	:	Due Date	: 3/28/2008 Qty: 10 Um: Each
Checked & Approved By	: <u>08 03 13</u>		
Comment	: Est Rev :A New Issue 08-01-11 EC verified by DD		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S125	6061-T6 .125 Sheet
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Comment: Qty.: 0.0893 sf(s)/Unit Total : 0.8925 sf(s)

6061 T6 sheet .125

Batch: 105646 HB 8-3-25

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3720

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

HB 8-3-25

08/04/01



(Ph)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

HB 8-3-25

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

08/04/01 (x16)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1


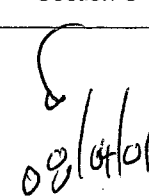
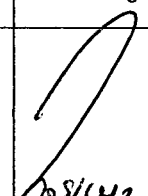
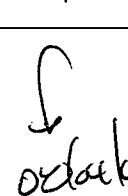
C'sink as per dwg D3720

08/04/01

x16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D 3720-1 PAR #: _____ Fault Category: Prod/Frg ^{used at small/water jet} NCR: Yes No DQA: D Date: 20/04/01
 QA: N/C Closed: D Date: 20/04/01

NCR: 37925D		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
02/04/01	± 2.0	small cut from water jet found on outer side	 20/04/01	one part scrap Scrap and Destroy Qty (+1) No rep/200	B 8-4-0	 08/04/01	 20/04/01	 02/04/01

NOTE: Date & initial all entries

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Drawing Name: STEP SPACER

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/04/02 (16)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M.A.

08/04/02

(16X)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BR

08-04-01

(16)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

SB

08/04/02

(16)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/03

16

Job Completion



MF

08-04-02

(16)

W

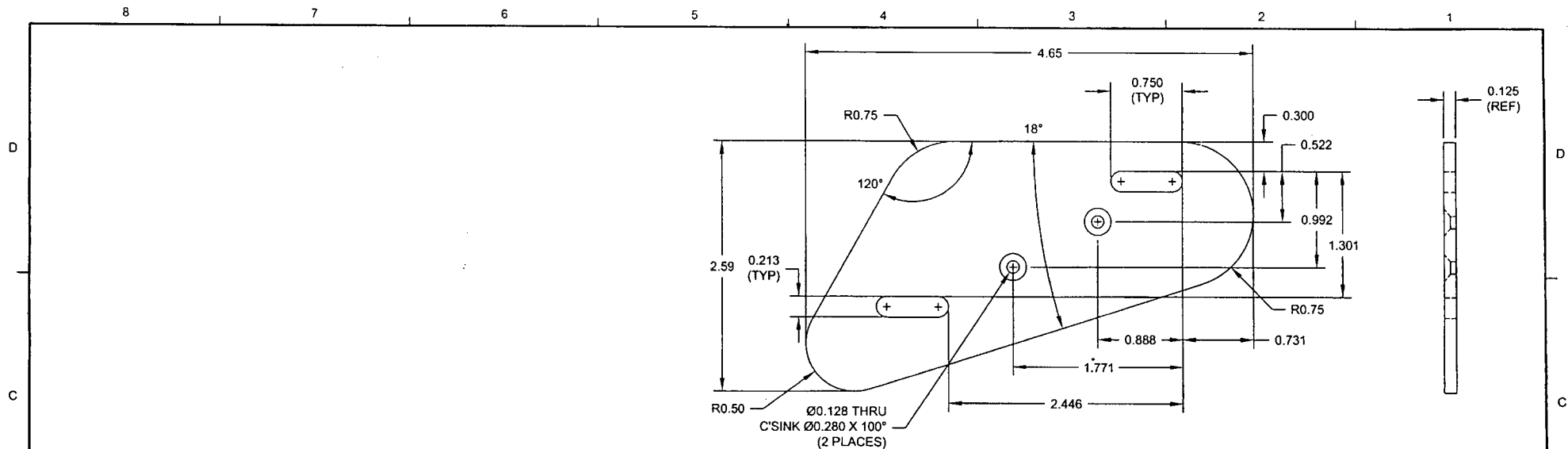
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

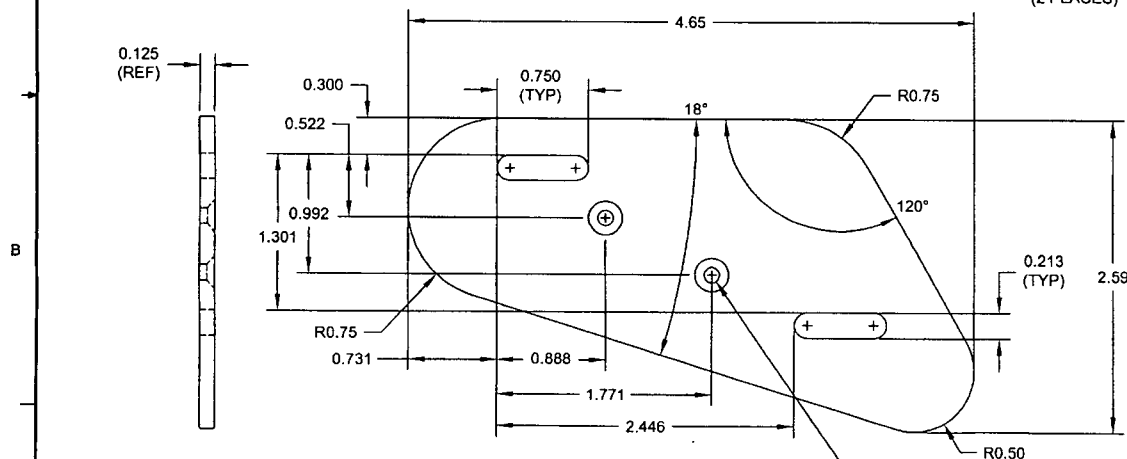
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3720-1 STEP SPACER



D3720-2 STEP SPACER

NOTES:

- 1) MATERIAL: 6061-T6 (OR -T62) ALUMINUM SHEET 0.125 THICK (PER QQ-A-250/11 OR AMS 4025/4027) (REF DART SPEC M6061T6S.125)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.08 lbs

NO. 379350
 UNCONTROLLED COPY
 EFFECT TO ENVIRONMENT
 WORK IN PROGRESS
 SHOP COPY
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 ENGINEERING

RELEASED
 06-01-10

A NEW ISSUE		PH	07.12.27
REV.	DESCRIPTION		BY DATE
DESIGN	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. A
DRAWN			SHEET 1 OF 1
CHECKED	DRAWING NO. D3720		SCALE
MFG. APPR.	TITLE STEP SPACER		1:1
APPROVED	DATE 07.12.27		
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